Wednesday, May 18, 2011 12:33:20 PM



Page 1

Item ID: D3325-041 Accept Setup Start **Revision ID:** Stop Item Name: Basket Lid Assembly **Start Date:** 5/18/2011 Start Qty: 1.00 **Cust Item ID:** Required Date: 5/23/2011 Req'd Qty: 1.00 **Customer:** Reference: Run Start Date: //- 05-18 Tooling: **Approvals: Process Plan:** Date: Stop Date: SPC (Y/N): QC: Date: Sequence ID/ **Operation** Set Up/ **Tool ID** Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description Qty Qty Code Number Stamp **Run Hours Draw Nbr Revision Nbr** D3325 Rev B 100 0.00 Large Fab Large Fab 0.00 Memo Large Fab 1-Cut tubes as per Dwg D3325 Qty□Part Number□ Description□ Batch 2□D3325-1□EndTube□ 3 □ D3325-3 □ Interior Tube □ 11 = 786 2□D3325-5□Full Lengh Tube □

2-Remove all markings from material

Identify parts appropriately

3-Drill and Weld as per Dwg D3325 & QSI 004 A/R□4130 ØSteel Rod□ 1000 75

4-Deburr as required

Dart A	Aeros	pace l	Ltd
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Dari Ae	rospace Lid		-	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,			
W/O:			WORK ORDER	CHANGES			•
DATE	STEP	PROCE	DURE CHANGE	Ву	Date	Qty Appr Chief Prod	Eng / Colpanyoter
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Part No		DAD #-	Fault Category:	NCP: Vos	No DO	\. Da	ite:
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			BK OBDER NON-CON				

NCR:			WORK	ORDE	ER NON-CONFORMANCE	(NCR)			
		Description of NC			Corrective Action Section B	·	Verification	Approval	Approval
DATE	STEP	Section A	Initi Chief I		Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Wednesday, May 18, 2011 12:33:20 PM



Page 2

Item ID:

D3325-041

Accept

Setup Start



Revision ID:

Item Name:

Basket Lid Assembly

Start Date:

5/18/2011

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 5/23/2011

Process Plan: _____ Date:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date: Date:_

Run Start

Stop

Stop



Sequence ID/ Work Center ID

QC

Quality Control

Operation Description

QC9- Inspect visual per QSI004- Fusion Welds

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

QC5- Inspect part completeness to step on W/O

120

Quality Control

Memo

Memo

121

HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

	-										
W/O:				WORK O	RDER CHANG	GES					
DATE	STEP	PRO	CEDURE	CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	i								
	Res	solution:								Date:	
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DATE	STEP	Description of NC	Initia		tive Action Sec etion Description	ction B	Sign &		cation		Approval
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Page 3

Insp.

Stamp

Wednesday, May 18, 2011 12:33:20 PM Item ID: D3325-041 Accept Setup Start **Revision ID:** Stop Item Name: Basket Lid Assembly **Start Date:** 5/18/2011 Start Qty: 1.00 **Cust Item ID:** Required Date: 5/23/2011 Req'd Qty: 1.00 **Customer:** Reference: Start Run Date: **Tooling: Approvals:** Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ Operation **Tool ID** Tool # Plan Reject Set Up/ Accept Reject **Work Center ID** Description Qty Number Code Otv **Run Hours** 130 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00 Powdercoat Memo Powder Coating 1ST COAT: OVEN TEMPERATURE M116964 START TIME: OVEN TEMPERATURE

140

Memo

QC3- Inspect Part Finish

0.00

0.00

Quality Control

W/O:]	WORK ORDER C	HANGES			• "
DATE	STEP	PR	OCEDURE	CHANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:						
	R	esolution:	Disp	osition:	QA: N/C Cld	osed:	Date: _	
NCR:			WORK (ORDER NON-CON	FORMANCE (NCR)		
DATE STEP		• Description of NC		Corrective Action		Verification	Approval	Approval
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NOTE: Date & initial all entries

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Wednesday, May 18, 2011 12:33:20 PM



Page 4

Item ID:

D3325-041

Accept

Setup Start



Revision ID:

Item Name: Basket Lid Assembly Stop

Start Date:

5/18/2011

Start Qty: 1.00

Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start



Required Date: 5/23/2011

QC:

Date:

SPC (Y/N):

Set Up/

Date:

Stop

Run



Sequence ID/ **Work Center ID**

150

Packaging

Operation Description

Identify as per dwg & Stock Location:

0.00

Run Hours

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Packaging

Memo

Memo

160

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

N/5/30/20

W/O:				٧	WORK ORDER CHANGES					
DATE	STEP	PROC	EDUR	E CH	HANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	_ Fau	lt Ca	ategory: NC	R: Yes	No DQA		_ Date:	·
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NCR:		v v	ORK	OR	RDER NON-CONFORMANC	E (NCI	R)			
DATE	STEP	Description of NC Section A	Init Chief		Corrective Action Section B Action Description Chief Eng	Sign Date			Approval Chief Eng	Approval QC Inspector
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Picklist Print

Wednesday, May 18, 2011 12:33:26 PM

Work Order ID: 69753

Parent Item: D3325-041

Parent Item Name: Basket Lid Assembly

Start Date: 5/18/2011

Start Qty: 1.00

Required Date: 5/23/2011

Page 1

Required Qty: 1.00

Comments:

IPP Rev:A□05.02.09□New issue□KJ/JLM

IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3328-1		Manufactured	No			100	Each	31.0000	2	$\frac{2}{\rho(1)}$	1.05.71	5	
				Location		Loc	<u>Otv</u>	Loc Code					
				WA005			31						
	•			3	33871		31		(A.		
03349-1		Manufactured	No			100	Each	36.0000	2	2			
pacer Bushing					•					-P	405-25		
				Location		Loc	<u>Oty</u>	Loc Code				t_{μ}	
				WA005			36						
				3	34205		8			(2)			
				4	44401		28				^		
3352-1		Manufactured	No			100	Each	18.0000		1	dlio	5.2	5
				Location		Loc	Otv	Loc Code		·			
				WA005			18		•				
بغر					41925		18		_	$\overline{\Omega}$	_		
03367-1		Manufactured	No			100	Each	36.0000	2	9	_ //	_	
Mounting Bracket				•							(p)	11.059	25
				Location		Loc	<u>Oty</u>	Loc Code					
	* * * * * * * * * * * * * * * * * * *	<u> </u>	-	WA005		**	36			\sim			
	·				43228		36 		4	(a)	_	-	

W/O:	•			V	ORK ORDER CHANGES					<u>v.</u> .
DATE	STEP	PROC	CEDURE	 		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	_ Faul	Ca	tegory:N	CR: Yes	No DQ	\ :	_ Date: _	
	R	•		1	ion: Q/				Date:	
NCR:		W	ORK	DR	DER NON-CONFORMANC	E (NCR).			
DATE	STEP	Description of NC	Im iAi		Corrective Action Section B	Sign &	Verific		Approval	Approval
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NOTE: Date & initial all entries

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Wednesday, May 18, 2011 12:33:26 PM

Work Order ID: 69753

D3325-041

Parent Item:

Parent Item Name: Basket Lid Assembly



Start Date: 5/18/2011

Required Date: 5/23/2011

Start Qty: 1.00

Required Qty: 1.00

M4130NTS0.500W.035

Purchased

100

20.5416 555.7500

4130 Square tube .500 x .500 x .035w

<u>Location</u>	Loc Qty
MAT034	555.75
109127	216
109385	15.75
112786	324

Loc Code

21.62274

Wednesday, May 18, 2011 12:33:26 PM

W/O:	· .		WORK ORDER CHANGES					, a
DATE	STEP	PROCEDUR	E CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Category:		NCR: Yes No DQA:	Date:
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	Resolution:		Disposition:		QA: N/C Closed:	Date:

NCR:		W	ORK	OR	DER NON-CONFORMANCE (NCR)	·		
DATE	STEP	Description of NC			Corrective Action Section B	Verification	Approval	Approval
DATE	SIEP	Section A	In it	ial Eng	Action Description Sign & Date	Section C	Chief Eng	QC Inspecto
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RETURN TO ENGINEERING UNCONTROLLED CO D3320-041 SUBJECT TO AMENDMENT WEBBING 03325-5 WITHOUT NOTICE FULL LENGTH TUBE (2) DETAIL C D3325-3 D3352-1 INTERIOR TUBE WORK ORDER LABEL PLATE \$ (TYP BOTH ENDS) TYP>VG \$0.128 HOLES ON THIS SIDE ONLY D3325-1 END TUBE (2) 4.00 --3.50 (TYP) 16.00 SEE DETAIL B FOR ATTACHMENT OF WEBBING TO FRAME Ø0.128+0.005 (TYP 3 HOLES EQUALLY SPACED AS SHOWN. 14.63 ---THRU INSIDE TUBE WALL ONLY) 10.25 D3325-1 END TUBE (SCALE 1:4) 29.50 -D3367-1 MOUNTING 34.50 BRACKET (2) 56.00 85.75±0.01 D3328-1 HINGE PLATE (2) D3325-3 INTERIOR TUBE D3349-1 (SCALE 1:4) SPACER (TYP BOTH ENDS) BUSHING 85.75 (6.50 PITCH) D3325-041 BASKET LID ASSEMBLY 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 6.50 **Ø0.128 HOLES ON THIS SIDE ONLY** (PRIOR TO INSTALLATION OF D3320-041) (TYP) 2) WELD PER DART QSI 004 3) ALL DIMENSIONS ARE IN INCHES 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3.37 03325-5 FULL LENGTH TUBE (TYP) (NOT TO SCALE) D3325-1/-3/-5 Ø0.128+0.005 PARTS LIST FOR D3325-041 BASKET LID ASSEMBLY 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST (TYP 13 HOLES, EQUALLY SPACED, 2) MATERIAL: 4130 COND. N SQ. TUBE, AMS-T-6736, 1/2" X 0.035 Part No Description PRODUCT ID LABE THRU INSIDE TUBE WALL ONLY) (REF. DART SPEC M4130N-TS0.500W.035) D2729-1 D3320-041 3) ALL DIMENSIONS ARE IN INCHES END TUBE D3325-1 4) ALL TOLERANCES ARE PER DART QSI. 018 UNLESS OTHERWISE NOTED D3325-3 FULL LENGTH TUBE D3325-5 D3328-1 D3349-1 SPACER BUSHING 05.04.25 CHANGE RIVET AND HOLE DIAMETER D3351-1 D3352-1 LABEL PLATE Α 04,10,21 NEW ISSUE MOUNTING BRACKET D3367-1 DESIGN MS20600AD4W3 DART AEROSPACE LTD. DART HIT @ 2004 BY DART AEROSPACE LTD. 91 PH AN960JD9 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN FERMISSION FROM DART AEROSPACE LTD. CHECKER 03325 SHEET I OF DEO ATTACHED DATE SCALE BASKET LID ASSEMBLY 05.04.25

SHOP COPY

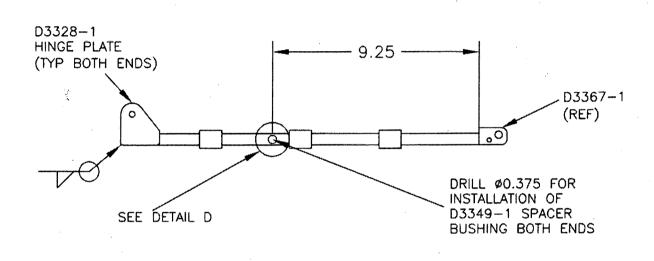
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DATE	STEP	Description of NC Section A	Initi Chief E		Si	gn & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

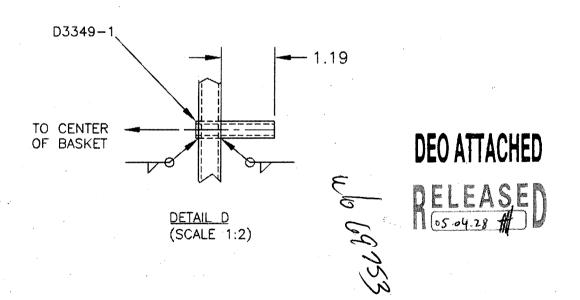
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	de	#	D3325 SHEET	2 OF	3
ı	DATE		TILE	SCA	LE
	05.04.25		BASKET LID ASSEMBLY	1	:4



VIEW A-A



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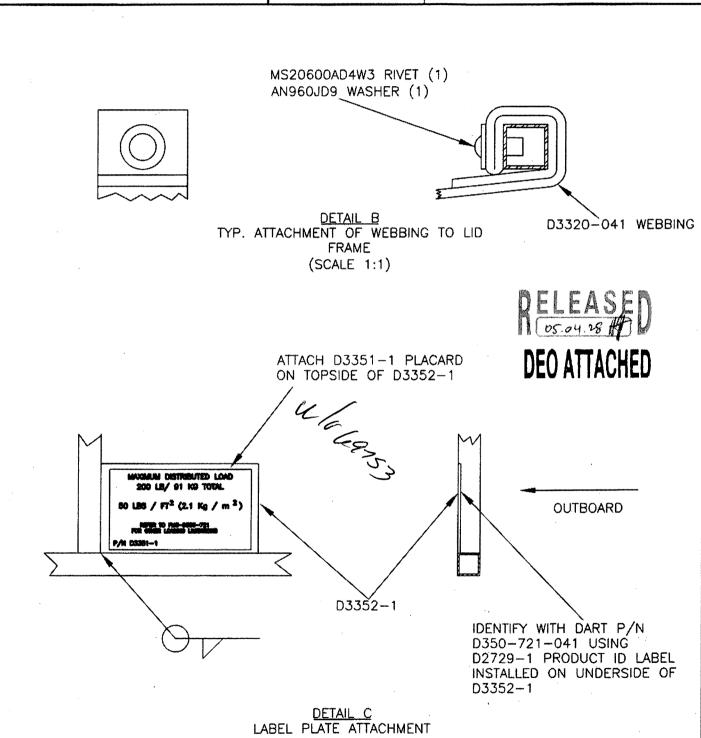
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W/O:			V	ORK ORDER CH	ANGES					
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DESIGN 844	DRAWN BY	DART AEROSPAO HAWKESBURY, ONTARIO,	
CHECKED	APPROVED	DRAWING NO. D3325	REV. B SHEET 3 OF 3
DATE		TITLE	SCALE
05.04.25		BASKET LID ASSEMBLY	1:4



(SCALE 1:2)

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W/O:			V	VORK ORDER CH	R CHANGES						
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DRAWING	NO.	TITLE		REV. B	DART AE	ROSPACE I	LTD	D.E.O. NO.		SHEET NO.	SCALE
D3325		BASKET LII	D ASSEMBLY	, 1	ENGINE	ERING ORD	ER	D3325-B-1		SHEET 1 OF 1	NTS
DRAWN	AJS		CHECKED		MFG. APPR.	$\overline{\mathcal{R}}$	AF	PROVED	M	DE APPR.	
DATE	08.11.	28	DATE	08.11.28	DATE	08.12.01	DA	ATE.	08.12.01	DATE 08.12.01	

1) SHEET 1 MODIFY PARTS LIST AS SHOWN:

PART LIST FOR D3325-041 BASKET LID ASSEMBLY

Part No.	Quantity	Description

IS:

	1	
	V	
MS20600AD4W5	32	RIVET
	1	

WAS:

	 /	
MS20600AD4W3	32	RIVET

2) UPDATE SHEET 3 DETAIL B ACCORDINGLY.

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W/O:				WORK ORD	ER CHANGES				*¶:
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Part No	•	PAR #:	Faul	t Category:	NC	R: Yes	No DQA:	Date:	
Resolution: Disp				osition:	QA	: N/C CI	osed:	Date: _	
NCR:			WORK	ORDER NON-	CONFORMANCI	E (NCF	R) _		
DATE	STED	STEP Description of NC		Corrective	<u>:</u>		Verification		Approval
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